

Date: Wednesday, 1/23/2008 11:38:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 36927
 Estimate Number : 11591
 P.O. Number :
 This Issue : 1/23/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2910
 First Issue : 1 / Type : SMALL /MED FAB Drawing Number : D2910 REV A
 Previous Run : 31827 Drawing Revision : A
 Material :
 Due Date : 1/30/2008 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : HJ 08 01 23
 Comment : Est B 02.11.12 Re-format, Incorporated D2911 and D2912 K
 J
 Est Rev:C Now on Waterjet 07-01-23 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.1623 sf(s)/Unit Total : 6.4932 sf(s)

6061-T6 .090 Sheet

Material: Sheet 6061-T6 x 0.090" thick

(M6061T6S.090)

Batch: 1059 HB 8-1-28

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2910

Dwg Rev: A

Prog Rev: A

HB 8-1-28

(44)

2-Deburr if necessary

HB 8-1-28

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-1-28

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

28/01/28 (44) counts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 08/02/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 36927

Part Number: D2910

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

SB 08/02/07

(44)

6.0

CHEMICAL TREAT

Hand Finish

CHEMICAL TREATMENT



Comment: CHEMICAL TREATMENT

Chemical conversion

HJ 08-02-08

(44)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/08 (44)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST53

AS 08/02/08

(44)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

(44)

Job Completion



2008/2/01

(44)

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

[illegible]

BENDING DETAIL

ENDING DET
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36927



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